

MAY 13 2015

Work Order ID 132297

132297

Page 1

Item ID: D2528-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Backer Plate

Start Date: 5/06/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/15/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2528	Rev C1								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2528 Dwg Rev: C1 Prog Rev: C1 2-
Deburr if necessary

5052 .063

(12)

MAY 15/05/07

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(12)

MAY 15/05/07

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

(12)

Dwg
38
9-89

MAY 07 2015

May-06-15 11:28:59 AM

132297

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Backer Plate

Stop *NS2*

Start Date: 5/06/15 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 5/15/15 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1

0.00

130

Memo

0.00

Hand Finishing

140 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Memo

0.00

Powdercoat

Powder Coating

START TIME:

FINISH TIME: 3:20

OVEN TEMPERATURE:

45.

150 QC3- Inspect Part Finish

0.00

150

Memo

0.00

QC

Quality Control

36

0.88

~~MAY 27 2015~~

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MAY 28 2015

Picklist Print

May-06-15 11:28:58 AM

Page 1

Work Order ID: 132297

132297

Parent Item: D2528-3

D2528-3

Parent Item Name: Backer Plate

Start Date: 5/06/15

Required Date: 5/15/15

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: C00.06.26Removed P/O for powder coatEC

IPP Rev:D 08-07-23 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased			No	110	sf	30.2849	0.0304	1			
M5052H32S 063									**				
5052-H32 .063 Sheet													

12/15/05/07

Location

Loc Qty

Loc Code

MAT022

30.2849

M128455

30.2849

7



DESIGN KE	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

RELEASED
98.12.11 KE

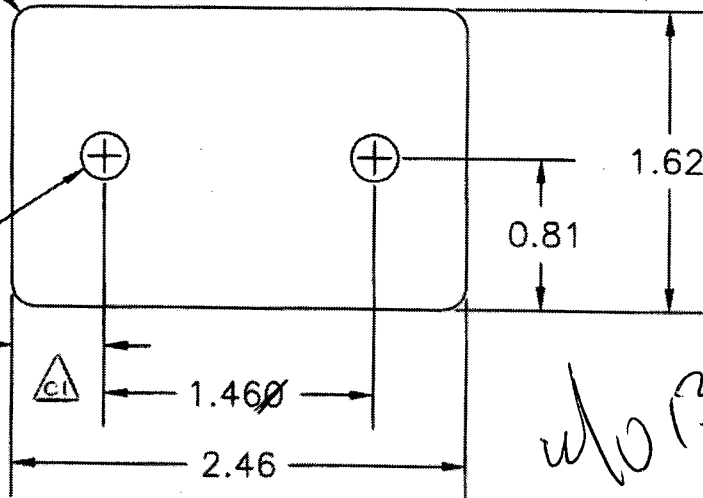
R0.13 (TYP)

UNDER REVIEW

OK 03.12.03

Ø0.257 (TYP)

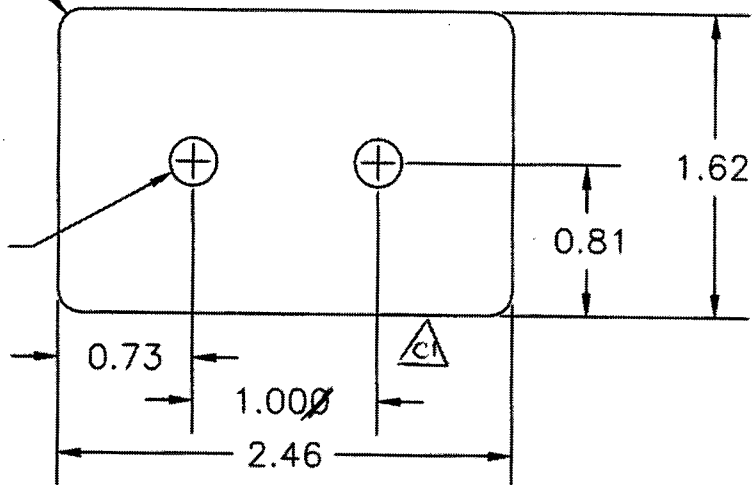
0.50



D2528-1

R0.13 (TYP)

Ø0.257 (TYP)



D2528-3

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED